

Work Order ID 68996

Wednesday, April 27, 2011 8:15:52 AM



Page 1

Item ID: D4349-15

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Placard

Start Date: 4/27/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CX

Date: 11/04/27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4349	PA# 7								
100		0.00							
Purchasing		0.00							
Purchasing	Memo								
	Issue P/O: <u>13952</u>								
	Manufacture as per Dwg D4349								
	Possible supplier: Studio Letrage								
	Material release note is required.								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging		0.00							
Packaging	Memo								
120	QC6- Inspect dimensions to drawing	0.00							
QC		0.00							
Quality Control	Memo								

CX 11/04/27 (2)

11/4/29 (2)



0.00 inspected to PA7

0.00 Daily

0.00 8/11/29 (2)

PRELIMINARY ISSUE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68996

Wednesday, April 27, 2011 8:15:52 AM

Page 2

Item ID: D4349-15

Accept

Revision ID: PRELIM

Item Name: Placard

Start Date: 4/27/2011 Start Qty: 2.00

Required Date: 4/27/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

ship to Eagle
attn: Hurney

CL 11/04/29 (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16

CL 11/04/29

POSITIVE RECALL

EFFECTIVE 11/24/20 AUTH CA
RELEASED DATE 4/25/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 8:15:49 AM

Page 1

Work Order ID: 68996



Parent Item: D4349-15



Parent Item Name: Placard



Start Date: 4/27/2011

Required Date: 4/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.04.27 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4349-15P  PLACARD		Purchased	No			110	Each	0.0000	1 	2			

Per 4/29/2011

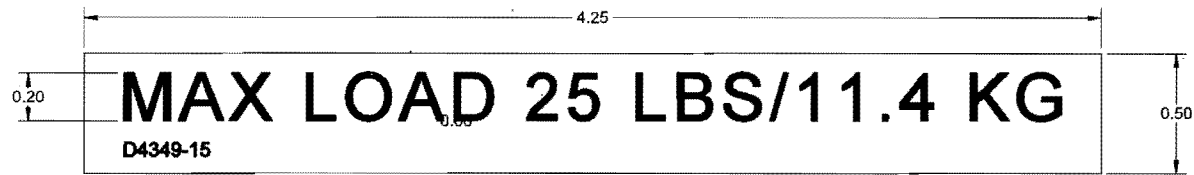
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4349-15 PLACARD

C211/04/27
W10:68996

PRELIMINARY ISSUE

11.03.03

NOTES:

- 1) MATERIAL: MANUFACTURED FROM ORAJET 3651 INTERMEDIATE GRADE CALENDERED PVC
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) BLACK LETTERS ON CLEAR ADHESIVE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4349	SHEET 11 OF 12
APPROVED		TITLE	SCALE
DE APPR.		SHELF	NTS
DATE	11.03.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13952**

Purchase Order Date 4/27/2011

PO Print Date 4/27/2011

Page Number 1 of 1

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Contact Name
Vendor Phone 613 632 5449
Vendor Fax 613 632 9491
Vendor Account Nbr

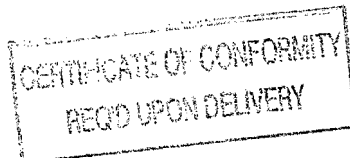
Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
C/L 11/6/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4349-15P	PLACARD	4/27/2011 Yes	2.00 Each	Yours ppd	\$30.0000 831.25	\$60.00
Special Inst:			AS PER DWG D4349 REV. PA6 B68996				
2	D4311-5P PRELIM	Placard	4/27/2011 Yes	2.00 Each	Yours ppd	\$30.0000 831.25	\$60.00
Special Inst:			AS PER DWG D4311 REV. PA6 B68997				

PO Total: \$120.00



Change Nbr: 1

Change Date: 4/27/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 15618
Date: 04/28/2011
Ship Date:
Page: 1
Re: Order No. 10717

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 869034678RP0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		2	D4349-15P setup	H	25.00	50.00
		2	D4311-5P setup	H	25.00	50.00
		1	printing	H	25.00	25.00
			H - HST 13%			
			HST			16.25
			PST Exempt: #6122-5207			
<i>869034678</i>						
Studio de Lettrage HST: #869034678RP0001						
Shipped By: Tracking Number:						
Comment: PO 13952						
Sold By:						
Total Amount						141.25



ORAJET 3651 Intermediate Grade Calendered PVC Inkjet Media

Description

5-year calendered PVC film available in transparent or in white with a gloss, semi-gloss, or matte surface.

Release Liner

90# PE-coated silicone paper

Adhesive

Grey, solvent-based, permanent

Areas of Use

General signage, vehicle graphics and other medium-term applications

Printing Techniques

Solvent inkjet

Thickness

(without paper and adhesive) 2.5 mil

Dimensional Stability

(FINAT TM-14) adhered to steel, no shrinkage in cross-direction; in length <.016"

Temperature Resistance

Adhered to aluminum -40°F to +176°F no variation

Adhesive Power

(FINAT-TM 1, after 24 h) adhered to stainless steel: 4.1 lb/in

Outdoor Durability

(based on vertical surface exposure) 5 years (unprinted)

Shelf Life

2 years

Seawaterability

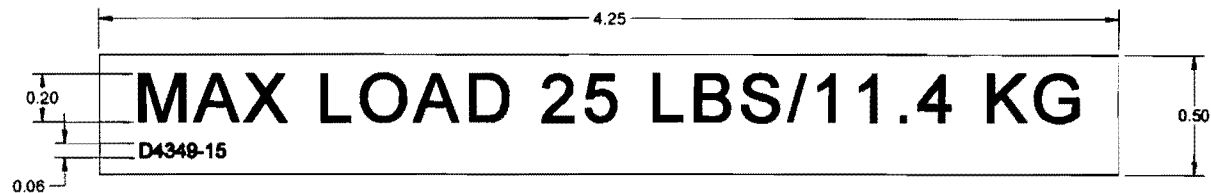
Adhered to aluminum, after 100 hours/73°F, no variation

Elongation at break (across)

150%

Elongation at break (along)

130%



D4349-15 PLACARD

68996

RELEASED
2011-05-18

- NOTES:
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 - 2) FINISH: N/A
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 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) BLACK LETTERS ON CLEAR ADHESIVE

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4349	SHEET 11 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHELF	NTS
DATE	11.03.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

